

Work Order ID 152381***152381***

Page 1

Monday, October 24, 2016 11:18:52 AM

Item ID: D350-578-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AS350/AS355 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 10/24/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 11/4/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **OCT 24 2016**

Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr						DAS 21 9-89		
D350-578	H								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-578-015 CHG002								
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.02							
Quality Control									

DEC 08 2016

NOV 16 2016

DEC 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
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LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

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NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
180									
Packaging	Memo	0.00		3		DAS 27 9-89			
Packaging	Identify and pack for shipping as per PPP D350-578-015 Location: <u>fg 012</u>								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.05				DAS 21 9-89			
Quality Control									

DEC 08 2016

DEC 09 2016

DEC 09 2016

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Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
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Page 1

152381

D350-578-015

Required Date: 11/4/2016

Required Qty: 3.00

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2432-3		Manufactured	No				Each	1.0000	2	6			
D2432-3									**	152429		NOV 14 2016	DAS 28 9-89
206 (24") Bearpaw													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST454a			1						DAS 27 9-89
				139891			1						DAS 26 9-89
D2529		Manufactured	No				Each	603.0000	2	36			
D2529									**				DAS 28 9-89
Washer													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST008			603						DAS 26 9-89
				150080			500						DAS 28 9-89
				150996			103						DAS 26 9-89
D3601-1		Manufactured	No				Each	29.0000	2	36			
D3601-1									**				DAS 28 9-89
Radius Block													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST045			29						DAS 26 9-89
				150996			1						DAS 28 9-89
				151014			28						DAS 26 9-89
D4011-1		Manufactured	No				Each	75.0000	6	18			
D4011-1									**				DAS 28 9-89
Clamp, Short													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST544			75						DAS 26 9-89
				151217			75						DAS 28 9-89

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Picklist Print

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D350-578-015

Parent Item Name: AS350/AS355 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 10/24/2016

Required Date: 11/4/2016

Start Qty: 3.00

Required Qty: 3.00

D4012-1

Manufactured No

Each

93.0000

6

18

D4012-1

Cushion

**

152436X3

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

5

133458

5

ST545

88

151095

46

151752

42

Each

68.0000

**

36

m/BS966e

DAS
26
9-89

NOV 18 2016

AN4-17A

Purchased

No

AN4-17A

Bolt

Location

Loc Qty

Loc Code

ST343

68

M135464

18

M135671

50

Each

2,230.000

**

36

NOV 18 2016

NAS1149D0463J

Purchased

No

NAS1149D0463J

Washer

Location

Loc Qty

Loc Code

cnc

200

M135671

200

GA

135

M134508

32

M135056

103

ST260a

1000

M135767

1000

ST263

895

M135530

95

M135671

800

36ex

NOV 18 2016

DQA: _____ Date: _____



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Start Date: 10/24/2016

Required Date: 11/4/2016

Start Qty: 3.00

Required Qty: 3.00

MS21042L4

Purchased

No

Each

2,214.000

36

MS21042L4

Nut

**

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

34

m133363

34

GA

260

m135058

260

OVER007

1500

m135774

500

m135864

1000

ST303

420

m135704

420

36x

DAS
26
9-89
DAS
26
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NOV 18 2016

DQA: _____ Date: _____



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																															
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																																																																																																																													
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Work Order ID 152381***152381***

Page 1

Monday, November 14, 2016 9:11:02 AM

Item ID: D350-578-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AS350/AS355 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 10/24/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 11/4/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-578	H								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-578-015 CHG002								
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.02							
Quality Control									

DAS
21
NOV 14 2016
3

5.0 PARTS LIST

5.1 D350-578-011/-013/-015/-017/-021 BEARPAW INSTALLATION

Qty -011	Qty -013	Qty -015	Qty -017	Qty -021	Qty -031	Part Number	Description
X						D350-578-011	BEARPAW INSTALLATION
	X					D350-578-013	BEARPAW INSTALLATION
		X				D350-578-015	BEARPAW INSTALLATION
			X			D350-578-017	BEARPAW INSTALLATION
				X		D350-578-021	BEARPAW INSTALLATION
					X	D350-578-031	WEARPLATE KIT
2						D2432F	Bearpaw
		2				D2432-3	Bearpaw
12	12	12	12	12		D2529	Washer
				2		D2672F	Bearpaw
12	12	12	12	12		D3601-1	Radius Block (Replaces D2274)
					2	D3859-041	Wearplate
6	6	6	6	6		D4011-1	Clamp (Replaces D2438)
6	6	6	6	6		D4012-1	Cushion (Replaces D2182B050)
	2					D4297-1	Bearpaw
			2			D4297-3	Bearpaw
12	12			12	12	AN4-16A	Bolt
		12	12		12	AN4-17A	Bolt
24	24	24	24	24	24	NAS1149D0463J	Washer
12	12	12	12	12	12	MS21042L4	Nut (or MS21042-4)

5.2 D350-578-111/-113/-115/-117/-121 BEARPAW INSTALLATION

Qty -111	Qty -113	Qty -115	Qty -117	Qty -121	Part Number	Description
X					D350-578-111	BEARPAW INSTALLATION
	X				D350-578-113	BEARPAW INSTALLATION
		X			D350-578-115	BEARPAW INSTALLATION
			X		D350-578-117	BEARPAW INSTALLATION
				X	D350-578-121	BEARPAW INSTALLATION
1					D350-578-011	Bearpaw Installation
	1				D350-578-013	Bearpaw Installation
		1			D350-578-015	Bearpaw Installation
			1		D350-578-017	Bearpaw Installation
				1	D350-578-021	Bearpaw Installation
1	1	1	1	1	D350-578-031	Wearplate Kit